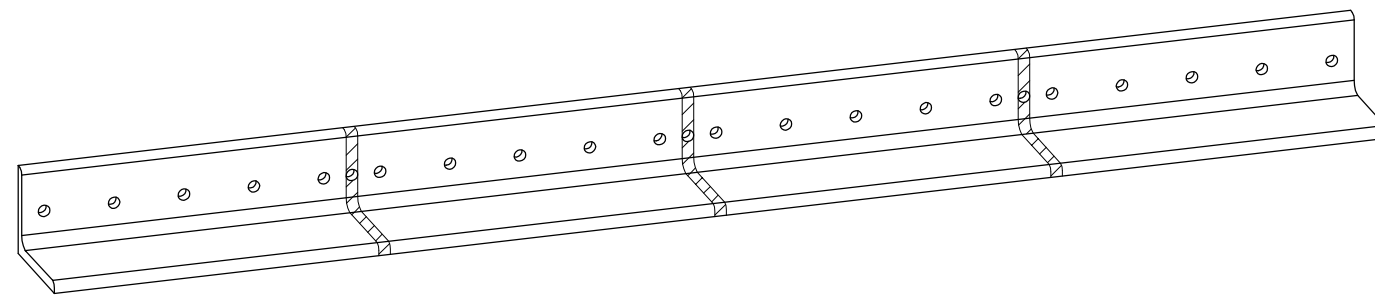
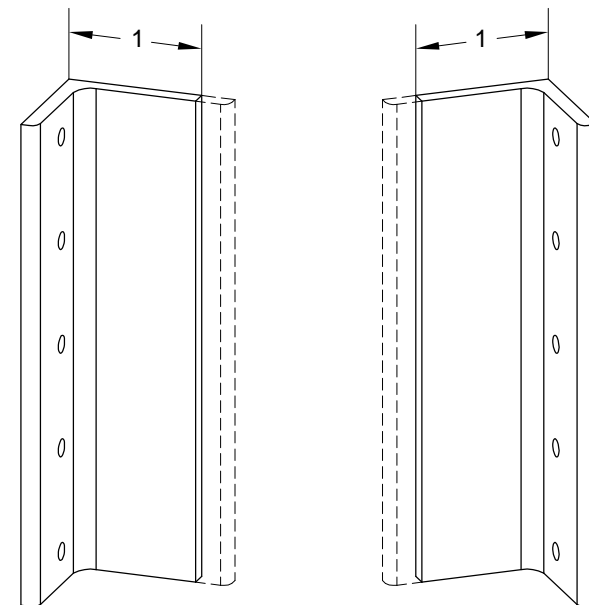


Step 1: Separate the F-1236 Step Attach Angles by removing the hatched areas shown in Figure 1.



**FIGURE 1: SEPARATE THE F-1236 STEP ATTACH ANGLES**

Step 2: As shown in Figure 2, make the F-1236B-L & -R Outbd Step Attach Angles by trimming the flanges of two of the angles separated in Step 1. (At this point these two parts are identical, but will become left and right once they are drilled in a later step.)

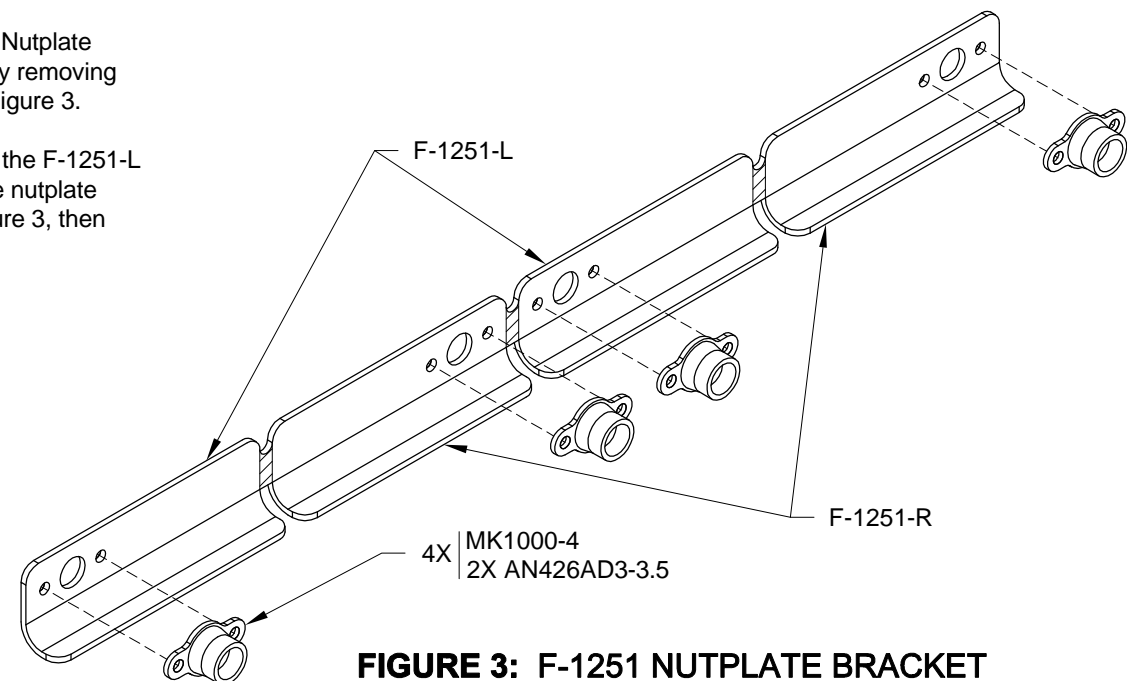


**FIGURE 2: F-1236B OUTBD STEP ATTACH ANGLES**

The two, remaining, untrimmed angles separated in Step 1 are designated F-1236A-L & -R Inbd Step Attach Angles.

Step 3: Separate the F-1251 Nutplate Bracket into individual parts by removing the hatched areas shown in Figure 3.

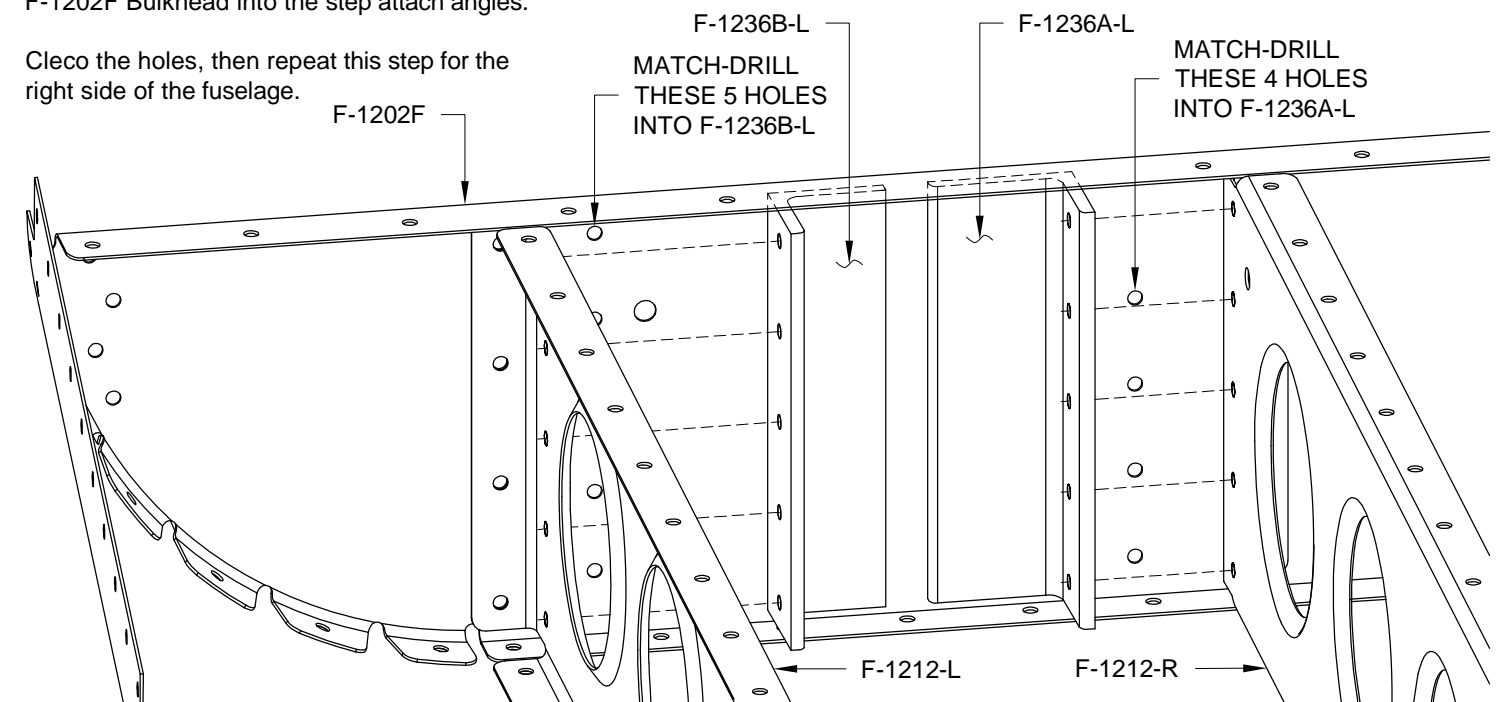
Step 4: Machine countersink the F-1251-L & -R Nutplate Brackets for the nutplate attach rivets called out in Figure 3, then rivet the nutplates in place.



**FIGURE 3: F-1251 NUTPLATE BRACKET**

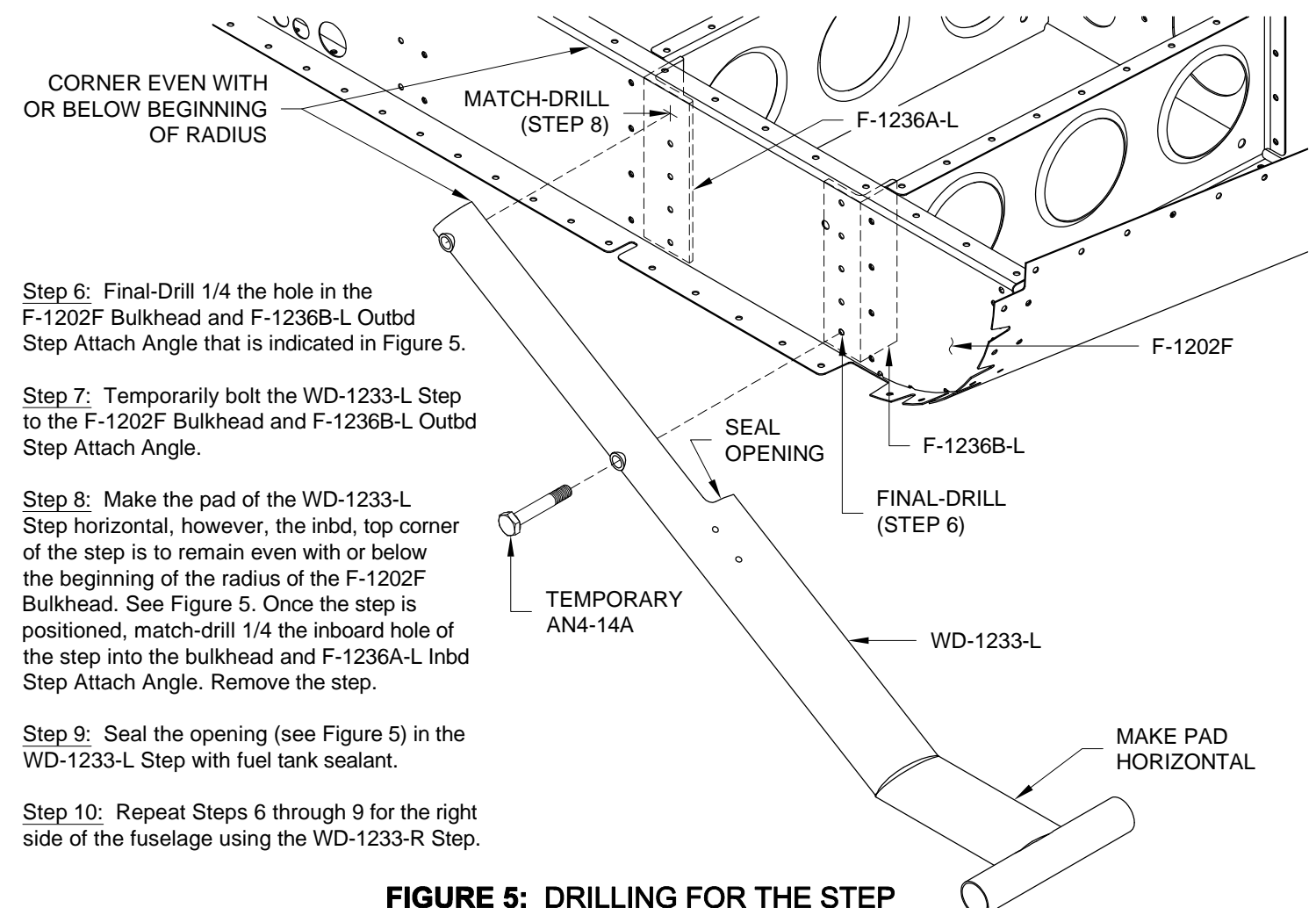
Step 5: Cleco the F-1236A-L Inbd Step Attach Angle to the F-1212-R Step Rib and the F-1236B-L Outbd Step Attach Angle to the F-1212-L Step Rib as shown in Figure 4, then match drill #30 the indicated holes of the F-1202F Bulkhead into the step attach angles.

Cleco the holes, then repeat this step for the right side of the fuselage.



**FIGURE 4: DRILLING THE STEP ATTACH ANGLES**

CORNER EVEN WITH OR BELOW BEGINNING OF RADIUS



Step 6: Final-Drill 1/4 the hole in the F-1202F Bulkhead and F-1236B-L Outbd Step Attach Angle that is indicated in Figure 5.

Step 7: Temporarily bolt the WD-1233-L Step to the F-1202F Bulkhead and F-1236B-L Outbd Step Attach Angle.

Step 8: Make the pad of the WD-1233-L Step horizontal, however, the inbd, top corner of the step is to remain even with or below the beginning of the radius of the F-1202F Bulkhead. See Figure 5. Once the step is positioned, match-drill 1/4 the inboard hole of the step into the bulkhead and F-1236A-L Inbd Step Attach Angle. Remove the step.

Step 9: Seal the opening (see Figure 5) in the WD-1233-L Step with fuel tank sealant.

Step 10: Repeat Steps 6 through 9 for the right side of the fuselage using the WD-1233-R Step.

**FIGURE 5: DRILLING FOR THE STEP**